

Work Order ID 84805

84805

Page 1

Item ID: D206-628-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step LH

Start Date: 23/05/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/23

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev N/A

E SP

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-011 CHG 003

S 12/07/10

OK for CL 12/7/10

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

3

12/07/06 JB

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

S 12/6/10

x3

LH

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D206-628-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step LH

Start Date: 23/05/2012 Start Qty: 3.00

3

Cust Item ID:

Required Date: 06/06/2012 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00

130

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-628-011
Location: _____
PPP Rev: 7

3x

SP
127/0

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

CK 12/7/11

01207-11

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

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84805

D206-628-011

Required Date: 06/06/2012

Required Qty: 3.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2721-041		Manufactured	No			110	Each	0.0000	1	3			
D2721-041 206B Step Assembly													
D2731-7		Manufactured	No			110	Each	72.0000	4	12			
D2731-7 Mounting Lug													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST			-50						
				ST468A			4						
				71860			4						
				ST469			118						
				78922			68						
D2732-030		Manufactured	No			110	Each	2.0000	8	24			
D2732-030 Rubber Cushion													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST402			2						
				76850			1						
				81499			1						
D3394-043		Manufactured	No			110	Each	112.0000	4	12			
D3394-043 Lug Assembly													
				<u>Location</u>			<u>Loc Qty</u>			<u>Loc Code</u>			
				ST479			112						
				78921			32						
				80217			60						
				82760			20						

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84805

84805

Parent Item: D206-628-011

D206-628-011

Parent Item Name: Heli-Access-Step LH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 3.00

Required Qty: 3.00

AN4-13A

Purchased

No

110

Each

1,513.000



12



AN4-13A

Bolt

**

JB

Location

Loc Qty

Loc Code

ST357

1513

119449

33

120187

19

120422

2

120770

394

121162

65

121652

1000

AN4-14A

Purchased

No

110

Each

344.0000



12



AN4-14A

Bolt

**

JB

12/07/06

Location

Loc Qty

Loc Code

357

100

121349

100

ST357

244

120187

13

120769

1

121068

17

121444

100

121708

113

121349

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 3

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Parent Item: D206-628-011

D206-628-011

Parent Item Name: Heli-Access-Step LH

Start Date: 23/05/2012

Required Date: 06/06/2012

Start Qty: 3.00

Required Qty: 3.00

AN4-15A

Purchased

No

110

Each

591.0000

4

12

AN4-15A

Bolt

**

122141 JB

Location

Loc Qty

Loc Code

358

100

121652

100

GA

100

120449

100

ST358

391

118706

3

120422

88

121444

100

121541

200

AN960JD416

NAS1149D0463J

Purchased

No

110

Each

30.0000

12

36

AN960JD416

Washer

**

121912 JB

Location

Loc Qty

Loc Code

ST351

30

116289

10

119097

20

MS21042L4

Purchased

No

110

Each

4,414.000

12

36

MS21042L4

Nut

**

JB 12/07/06

Location

Loc Qty

Loc Code

ST300

4414

119075

125

121011

1032

121444

2957

121652

300

121444

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Shop Packet Print

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.1 D206-628-011/-012/-021/-022/-031/-032 REGULAR DART HELI-ACCESS- STEPS™ PARTS LIST

Qty -011-	Qty -012	Qty -021	Qty -022	Qty -031	Qty -032	Part Number	Description
X						D206-628-011	206 A/B STEP INSTALLATION LH
	X					D206-628-012	206 A/B STEP INSTALLATION RH
		X				D206-628-021	206 L/L1/L3/L4 STEP INSTALLATION LH
			X			D206-628-022	206 L/L1/L3/L4 STEP INSTALLATION RH
				X		D206-628-031	407 STEP INSTALLATION LH
					X	D206-628-032	407 STEP INSTALLATION RH
/ 1						D2721-041	STEP ASSEMBLY LH
	1					D2721-042	STEP ASSEMBLY RH
		1		1		D2724-041	STEP ASSEMBLY LH
			1		1	D2724-042	STEP ASSEMBLY RH
				4	4	D2731-3	MOUNTING LUG
/ 4	4	4	4			D2731-7	MOUNTING LUG
/ 8	8	8	8	8	8	D2732-030	RUBBER CUSHION
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*MOUNTING LUG
				8	8	*MS35489-93	*GROMMET
/ 4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*MOUNTING LUG
8	8	8	8			*MS35489-93	*GROMMET
/ 4	4			4	4	AN4-13A	BOLT
/ 4	4	4	4	4	4	AN4-14A	BOLT
/ 4	4	8	8	4	4	AN4-15A	BOLT
/ 12	12	12	12	12	12	NAS1149D0463J	WASHER (AN960JD416)
/ 12	12	12	12	12	12	MS21042L4	NUT (OR MS21042-4)

*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

RELEASED
05-11-14

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

— REFER TO STEP
END DETAIL

D2721-1
MAKE FROM EXTRUSION D2622-078

D2721-041-LH STEP ASSEMBLY-(SHOWN)
D2721-042 RH STEP ASSEMBLY-(OPPOSITE)

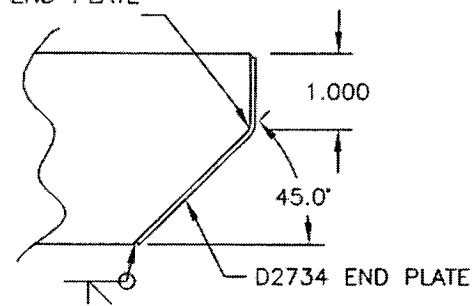
ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE


D2721-041/-042 STEP ASSEMBLY PARTS LIST

CITY - Q41	QTY - Q42	PART NUMBER	DESCRIPTION
X	X	D2721-041	LH STEP ASSEMBLY
		D2721-042	RH STEP ASSEMBLY
1	1	D2622-076	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-2	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



TYPICAL STEP END DETAIL 

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